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D2012-105
Job Sheet 164391



Part No: D2012-105

Job Qty: 2 ea

Part Name: Arm (31.06)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/2/17

Job Tracking No:

Due Date: 10/31/17

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV E IPP Rev: I 02.04.03 Added Inspect level 3 NG

Ship Via:

Bill of Materials

Part/Part Name	Part Note	Serial No	Quantity	Location
D2012-105 Arm (31.06)	DWG REV E IPP Rev: I 02.04.03 Added Inspect level 3 NG		0.000	
M304TR0.500W.035 304 Round Tube .500 X .035W			0.000	

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	2 Ea	10/30/17	0.00	0.00	Start up container	
110	Small Fab ✓	2 pcs	10/31/17	0.00	2.98	Small Fab	
120	QC	2 pcs	10/31/17	0.00	0.00	QC5	
130	Powdercoat ✓	2 pcs	10/31/17	0.00	0.00	Powdercoat4	0.045
140	QC	2 pcs	10/31/17	0.00	0.00	QC3	
150	Packaging	2 pcs	10/31/17	0.00	0.00	Packaging3	
160	QC21-SA	2 Ea	10/31/17	0.00	0.00	QC21	

Part Op 110 - 1-Debur

Descriptions: 120 - Use DT10255 TO CHECK PART

130 - START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Special Comments
D2012-105 B164391		4 Ea (2 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2012-105 B164391	4	2	

Part Specifications

Specifications could not be

Status: Stock

Part: **D2012-105 B164391**

Created: 9/30/17 11:26 AM DART.MICHAUD-FEBRILLE.VICTORIA



Serial No: **S000053**

Printed By: Goldston, Justin 10/2/17 10:44 AM

W I P

PART NO: D2012-105

Revision:

Operation: Start up Operation

Quantity: 2

Next Op: 110 Small Fab

Arm (31.06)

SERIAL NO: S000474



Job #: 164391

Mfg Date: 10/13/17

OCT17

Work Order Summary

Thursday, September 28, 2017 10:01:37 AM

Page 1 of 1

Criteria : Work Order ID: 164391 Item ID: D2012-105 Product Family SMALL FAB
 Work Order Start Dates 7/12/2017 to 7/12/2017 11:59:59 PM Work Order Required Dates 7/19/2017 to 7/19/2017 11:59:59 PM
 All References
 Work Order Status Released

Work Order ID	164391	Required Qty	2.0000	Status Code	Released
Item ID	D2012-105	Accepted Qty	0.0000	Scrap Qty	0.0000
Item Name	Arm (31.06)				
Current Acct Value	\$53.530				
Start Date	7/12/2017	Required Date	7/19/2017	Completed Date	
Standard	** Actual **		** Acct. Value **	** Variance **	** Variance % **
Direct Costs	Total	Each	Each	Each	Each
Material	\$8.295	\$0.000	\$4.148	\$4.148	100.00%
Labor	\$29.732	\$0.000	\$15.986	\$15.986	100.00%
Outplant	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Variable Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Fixed Burden	\$67.918	\$0.000	\$33.396	\$33.396	100.00%
Material Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
** Total **	\$105.945	\$0.000	\$53.530	\$53.530	

Item ID/Item Name	Required Qty	Issue Code	Issue Date	Issued Qty	Cost Amount
M304TR0.500W.035					
304 RD Tube .500 x .035W	5.5272		9/28/2017	5.5300	\$8.295
Total Matl Amts:					\$8.295

Work Center Brake NC

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
LECL01												
7/27/2017												
100			0.00	0.00	0.84	0.84	1.00	\$0.000	\$18.019	\$36.575	\$0.000	\$54.594
Total:			0.00	0.00	0.84	0.84	1.00	\$0.000	\$18.019	\$36.575	\$0.000	\$54.594

Work Center Small Fab

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
LECL01												
7/27/2017												
110			0.00	0.00	0.57	0.57	1.00	\$0.000	\$11.713	\$31.343	\$0.000	\$43.056
Total:			0.00	0.00	0.57	0.57	1.00	\$0.000	\$11.713	\$31.343	\$0.000	\$43.056

Work Order ID 164391

Wednesday, July 19, 2017 11:19:09 AM

164391

Page 1

Item ID: D2012-105 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Arm (31.06)
Start Date: 7/12/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 7/19/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan:  Date: JUL 20 2017 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2012-105	E

100

0.00

100

NC BRAKE

Brake NC

Memo

0.34

Brake NC

Punch to length as per Dwg D2012-105 & template D2012-105T1 and DT8116
Use DT10255 TO CHECK PART

2  MLL
17-7-27

110

0.00

110

Small Fab

Small Fab

Memo

0.25

Small Fab

1-Deburr



120

QC5- Inspect part completeness to step on W/O

0.00

120

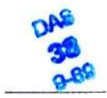
QC

Memo

0.04

Quality Control

Use DT10255 TO CHECK PART

2  OCT 13 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																												
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																								
Root Cause		FAULT CATEGORY																																																														
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Misaligned/off center ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																															

Work Order ID 164391

Wednesday, July 19, 2017 11:19:09 AM

164391

Page 2

Item ID: D2012-105

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Arm (31.06)

Start Date: 7/12/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 7/19/2017 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

130

Powdercoat

Memo

0.18

Powder Coating

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.20

Quality Control

150

Identify as per dwg & Stock Location: _____

0.00

150

Packaging

Memo

0.02

Packaging

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
		OTHER :							

Wednesday, July 19, 2017 11:19:09 AM

164391

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

2

2

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/
Run Hours**Tool ID****Tool #****Plan
Code**

Accept Qty

Reject
QtyReject
Number

**Insp.
Stamp**

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.20

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

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Wednesday, July 19, 2017 11:19:12 AM

Work Order ID: 164391

164391

Parent Item: D2012-105

D2012-105

Parent Item Name: Arm (31.06)

Start Date: 7/12/2017

Required Date: 7/19/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:102.04.03Added Inspect level 3NG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.035		Purchased			No	100	f	85.5028	2.6254	5.527158			

M304TR0 500W 035

304 RD Tube .500 x .035W

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA	85.502796	
m137086	14.025477	
m137199	2.300579	
m137286	0.02674	
m137415	27.6	
m137623	1.55	
m137834	40	

5.53

MLL

17-7-27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																